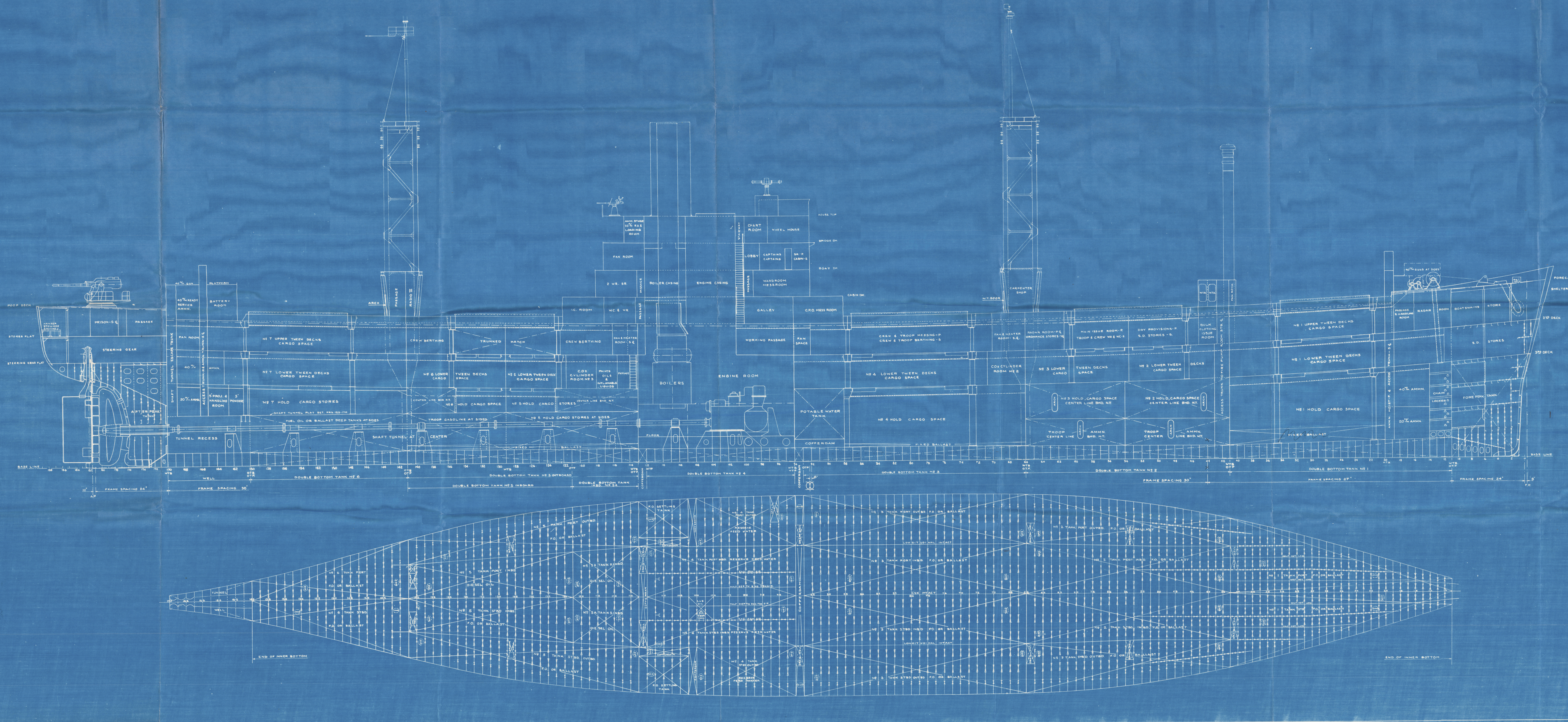
KA 102

MARK	PANEL NO	ALTERATIONS	DATE	O.K.	AUTH'D	APP'D	DATE
	A	PLAN MADE APPLICABLE FOR ADDITIONAL CONTRACT BY ALTERING AKA, M.C., & N.C. HULL NUMBERS.	R.C.P. 12/6/44				

NOTES

NO. 1. THIS DRAWING ~~REPLACES N.N. DRAWING~~ IS NEW
~~M.C. No.~~ FOR HULLS LISTED BELOW.



S.S. "Beatrice"
Baltimore Rpt.
8451

①

1405	150			1404	149		
1403	148		"	1402	147		
1401	146		"	1400	145		
1399	144		"	1398	143		
1397	142		"	1396	141		
1395	140		"	1394	139		
1393	138		"	1392	137		
1391	136		"	1390	135		
1389	134		"	1388	133		
1387	132		"	1386	131		
1385	130		"	1384	129		
1383	128		"	1382	127		
M.C. HULL	N.C. HULL	AKA HULL	CONVERSION YARD	M.C. HULL	N.C. HULL	AKA HULL	CONVERSION YARD

DESIGN No. C2-S-AJ 3
CONVERSION OF C2-S-AJ 1

UNITED STATES MARITIME COMMISSION
M.C. HULL Nos. ~~1382 TO 1405~~ 1696-1703 & M.C. DWG. NO

NAVY DEPARTMENT
A. K. A. HULL Nos. 64-87 & 101-108

DESIGNED BY
NEWPORT NEWS SHIPBUILDING & DRY DOCK COMPANY
NEWPORT NEWS, VIRGINIA
HULL DEPARTMENT

SCALE 1/8 IN = 1 FT. DATE SCHED. DATE COMP. 3-15-44
DRAWN H. HUNTLEY EXAMINED R. W. Davis J. M. Bandy
CHECKED 3/13/44 APPROVED
CHARGEMAN J. E. Lake DATE

N. N. JOB ORDER 644-V
N. N. DRAWING No. 179470

NORTH CAROLINA SHIPBUILDING COMPANY
WILMINGTON N. C.
BUILDERS
N. C. HULL Nos. ~~127 TO 150~~ 187-194 & N. C. DWG. No. 179470
CONVERSION YARD

DWG. TITLE

INBOARD PROFILE AND DOUBLE BOTTOM

APPROVED AS NOTED IN
M. C. LET
M. C. FILE
BY
BY
A.B.S. LET.
U. S. COAST GUARD
Noted

LLOYD'S REGISTER OF SHIPPING
17 MAY 1944
NEW YORK
N.Y.

PLAN
EXAMINED AND FOUND CORRECT
SUPERVISOR OF SHIPBUILDING
DATE

APPROVED
DATE 3-24-44
E L Gayheart
FOR SUPERVISOR OF SHIPBUILDING

BUREAU OF SHIPS PLAN NUMBER (BASIC)
A.K.A. 64-S0103-507443 ALT. 0

ORDER DEPARTMENT
YARD PRINTS & ORDERS BILLS & ORDERS
PRINTS
REMARKS
DATE SIGNED

2-29-44 HG JEL WMP OAM JGW EG EDP EDM 3-16-44 up. JEL 3/18/44 HTD	3-25-44 HG HT JEL WMP OAM JGW EE EDP EDM CB JEL NS 4 MCL	4/11/44 HE 3AH AHP ML FN TS WE SC RH SI PB SE ABS PT BOS 2EL PD	[illegible] 3AHP 4/7/44 [illegible] 5/4/44 MAIL 5/10 3 mail 5/25/44 3 Mail 6/9 Bound	6/14/44 2PT 6/19 2 Mail TS 7/20 TS 8/4 Mail	10/13 NAVY				

GROUP:

007977-007980-0154

MARK	PANEL NO.	ALTERATIONS	DATE	O.K.	AUTH'D	APP'D	DATE
A		PLAN MODIFIED IN GENERAL			D		
B	GENERAL	PLAN ALTERED IN GENERAL: N.C. PLAN NO.S AND MATERIAL GROUP NO.S ADDED TO SUIT YARD PRACTICE	F.H.R. 2/24/44		2/25/4		
C	14	DETAILS 14A & 14B ADDED TO SUIT REF 20. REF 20 ADDED	CEM 3-16-44				
D		FRAMING BRACKETS DELETED IN WAY OF MISC. BULKHEADS ON 2ND DECK - TO SUIT REF 21 & 22 : REF 21 & 22 ADDED.	CEM 3-21-44				
E	2' 3'	DETAIL 2R ADDED FOR FRS. 15 & 17 TO SUIT REF NO. 23 : REF NO. 23 ADDED.	CEM 3-25-44		3/30/44		
F	12'	DET. "12-0" FRAMING BRKT. FOR FR. 101 PORT ONLY ADDED TO SUIT INSTALLATION OF MAIN OVERBOARD DISCHARGE.	4/10/44 RER		4-13-4		
G	6'	CHANNEL FR. 117 ALTERED TO TOE AFT FROM SHELTER DECK TO CABIN DECK TO SUIT REFERENCE NO. 24 & No. 10	F.H.R. 4-20-44		4-24-4		
H	1 5' 6' 9' 10'	FR. 96 MADE 12"x3½"x30.9# C BET. 2ND. DK. & MACHRY FLAT. CONN. OF TRANS. BEAM UNDER MACHRY. FLAT AT FR. 106 PORT ONLY NOTED TO SEE REF. # 14 DET. 9-8 & 10-D ALT. TO SUIT BEAM SIZES UNDER MACHRY. FLAT ALL TO SUIT REF. # 14. IN ACCORD WITH N.N. ALT. 1	4/25/44 R.E.W.		4/26/4		
	2 2' 3' 7'	DET. 2B, 3-B & 7-B REVISED TO SUIT REF. # 5. IN ACCORD WITH N.N. ALT. 2					
	3 4' 6'	NOTES ADDED AT BRKTS. IN WAY OF I.B. AT FRS. 45 & 138. ALL TO SUIT REF. # 20 IN ACCORD WITH N.N. ALT. 3					
J	8'	AT FR. 60 STBD ONLY - 18"x24" FLG. BRKT. ALT. TO 2'-0"x2'-6". ALTERNATE DET. 8-B ADDED - TO SUIT ENGR'S.	G.F.G. 6-27-44		6/27/4		
K	4'	SHELL FRAME SHOWN CUT. FRS. 38, 39 & 40. TO 3RD DECK. TO FACILITATE ERECTION & LAYOUT	F.H.R. 7-5-44		7/10/4		
L		PLAN MADE APPLICABLE TO ADDITIONAL CONTRACT BY ALTERING AKA, M.C. & N.C. HULL NOS	J.M.K. 8-2-4		10-13-4		
M	7'	BHD AT FR. 162 ADDED FROM I.B. TO FLAT FOR HULLS 149, 150 & 187-194. TO SUIT REF. 25. REF. 25 ADDED.	10/11/4 RER		10-13-4		

NOTES:

THIS DRAWING REPLACES N N DRAWING 178006

M.C. NO. 1346 S11-3-5ER FOR HULLS LISTED BELOW

ALL MATERIAL WAS ORDERED ON THE ORIGINAL PLAN EXCEPT AS MODIFIED BY ALTERATION "A"

REFERENCES

NO.	TITLE	C2-S-AJ1 N.N. NO	C2-S-AJ1 N.C. NO	C2-S-AJ3 N.N. NO	C2-S-AJ3 N.C. NO
1	HOLD STRINGERS	~~178007~~	S11-4-2	179553	179553
2	TRANS. W.T. BHD 11 & CHAIN LOCKER	~~178011~~	S11-5-8	179557	179557
3	2ND. DK. PLTG., BEAMS, & GIRDERS	~~178026~~	S11-6-4	179570	179570
4	SHAFT ALLEY BHDS	~~178023~~	S11-5-12	179404	179404
5	SHELTER, FOCLE, & POOP DK. PLTG.	~~178035~~	S11-6-7	179574	179574
6	BOW FRAMING FORD FR 11.	~~178009~~	S11-3-4	179555	179555
7	TRANS. BHD 170 & SHAFT ALLEY ESC. TRK	~~178020~~	S11-5-13	179565	179565
8	STERN FRAMING	~~178008~~	S11-3-6	179554	179554
9	3RD DK PLTG. BEAMS & GDRS.	~~178016~~	S11-6-6	179480	179480
10	SHELTER DK. HOUSE & CABIN DK. PLTG.	~~178039~~	S11-9-3	179575	179575
11	MAIN INJECTION SEACHESTS	~~174444~~			
12	AUX. SEA CHESTS	~~174445~~			
13	MISC BHDS BEL 3RD DK.			179427	179427
14	MACHY FLAT & FDNS. 17'-3" ABV. ℄ FR 94-107	~~178031~~	S11-13-4	179585	179585
15	MISC BHDS. BET 2ND & 3RD DKS.			179449	179449
16	PROTECTION FOR DEGAUSSING CABLES	~~179183~~		179704	179704
17	W.T. FLATS FR. 14-20 - 15'-0" ABV ℄ & 42-66 - 12'-0" ABV ℄			179423	179423
18	W.T. & O.T. FLAT. FR 129-170 - 15'-0" ABV. ℄			179426	179426
19	TRS. W.T. BHD. # 53½ ABV. 3RD DK.			179396	179396
20	SEA CHESTS IN DIESEL FIRE PUMPROOMS			179433	179433
21	MISC. BULKHEADS ON 2ND DK. FWD. FR 80			179429	179429
22	MISC. BULKHEADS ON 2ND DK AFT FR 80			179425	179425
23	40 M/M GUN FOUNDS. & AMM TRUNKS FORD.			179598	179598
24	MISCL. VENTILATION SHT. NO. 1			179662	179662
25	FOG OIL TANK FRS. 160-162				HPD128

M C HULL	N C HULL	A K A HULL	CONVERSION YARD	M C HULL	N C HULL	A K A HULL	CONVERSION YARD
1405	150			1404	149		
1403	148			1402	147		
1401	146			1400	145		
1399	144			1398	143		
1397	142			1396	141		
1395	140			1394	139		
1393	138			1392	137		
1391	136			1390	135		
1389	134			1388	133		
1387	132			1386	131		
1385	130			1384	129		
1383	128			1382	127		

DESIGN No. C2-S-AJ3

CONVERSION OF C2-S-AJ1

UNITED STATES MARITIME COMMISSION

M. C. HULL Nos. 1382 TO 1405 M. C. DWG No. 1856701703

NAVY DEPARTMENT

A. K. A. HULL Nos. 64 - 87 & 101-108

DESIGNED BY

NEWPORT NEWS SHIPBUILDING & DRY DOCK COMPANY

NEWPORT NEWS, VIRGINIA

HULL DEPARTMENT

SCALE ½" = 1 FT. DATE SCHED. ____ DATE COMP. 2-10-44

DRAWN Philip H. Clark EXAMINED

CHECKED C. W. HACKER APPROVED J. P. Comstock

CHARGEMAN ____ DATE Feb. 11, 1944

N. N. JOB ORDER 644-V N. N. DRAWING No. - 179552

NORTH CAROLINA SHIPBUILDING COMPANY

WILMINGTON, N. C.

BUILDERS

N. C. HULL Nos. ~~127 TO 150~~ 187-194 N. C. DWG No. 179552

CONVERSION YARD

DWG. TITLE

FRAMING DIAGRAM & DETAILS

APPROVED AS NOTED IN

M C LET. ____ A. B. S. LET. ____

M C FILE ____

BY ____

BY ____

U. S. COAST GUARD ____ APPROVED

EXAMINED AND FOUND CORRECT ____ PLAN

DATE 2-11-44

SUPERVISOR OF SHIPBUILDING ____

E. L. Gayhart

ASST. SUPERVISOR OF SHIPBUILDING

DATE ____

BUREAU OF SHIPS PLAN NUMBER (BASIC)

AKA 64 - S1103-507017

(9)

S.S. "Beatrice"
Baltimore Rpt.
8451

GROUP NUMBER	DESCRIPTION		FRAMES		
S11-20-C	FLOORS AT INNER BOTTOM		50½	TO	62½
S11-21-C	" " " "		37½	TO	50½
S11-24-C	" " " "		146½	TO	157½
S11-26-C	" " " "		11½	TO	24½
S11-49-	WEB FRAMES INNER BOTTOM		22, 47, & 60		
S11-60-A1	FRAMING BRACKETS	I.B. TO 3RD DK.	62½	TO	122½
S11-60-A2	SHELL FRAMING	" " " "	"	"	"
S11-60-B1	FRAMING BRACKETS	3RD DK. TO 2ND DK.	"	"	"
S11-60-B2	SHELL FRAMING	" " " "	"	"	"
S11-60-C1	FRAMING BRACKETS	2ND DK. TO SHLTR. DK.	"	"	"
S11-60-C2	SHELL FRAMING	" " " "	"	"	"
S11-60-D2	" "	SHELTER DK. TO CABIN DK.	83½	TO	125
S11-61-A1	FRAMING BRACKETS	I.B. TO 3RD DK.	24½		62½
S11-61-A2	SHELL FRAMING	" " " "	"		"
S11-61-B1	FRAMING BRACKETS	3RD DK. TO 2ND DK.	"	"	"
S11-61-B2	SHELL FRAMING	" " " "	"	"	"
S11-62-A1	FRAMING BRACKETS	I.B. TO 3RD DK.	11½	TO	24½
S11-62-B1	" "	3RD DK TO 2ND DK.	"	"	"
S11-62-B2	SHELL FRAMING	" " " "	"	"	"
S11-63-A1	FRAMING BRACKETS	I.B. TO 3RD DK.	122½	TO	140½
S11-63-A2	SHELL FRAMING	" " " "	"	"	"
S11-63-B1	FRAMING BRACKETS	3RD DK. TO 2ND DK.	"	"	"
S11-63-B2	SHELL FRAMING	" " " "	"	"	"
S11-64-A1	FRAMING BRACKETS	I.B. TO 3RD DK.	140½	"	157½
S11-64-A2	SHELL FRAMING	" " " "	"	"	"
S11-64-B1	FRAMING BRACKETS	3RD DK TO 2ND DK.	"	"	"
S11-64-B2	SHELL FRAMING	" " " "	"	"	"
S11-65-A1	FRAMING BRACKETS	I.B. TO 3RD DK.	157½	TO	169½
S11-65-A2	SHELL FRAMING	" " " "	"	"	"
S11-65-B1	FRAMING BRACKETS	3RD DK TO 2ND DK.	"	"	"
S11-65-B2	SHELL FRAMING	" " " "	"	"	"
S11-77-A	FRAMING BRACKETS	2ND DK. TO SHLTR. DK.	122½	TO	146½
S11-77-B	SHELL FRAMING	" " " "	"	"	"
S11-78-A	FRAMING BRACKETS	" " " "	146½	TO	169½
S11-78-B	SHELL FRAMING	" " " "	"	"	"
S11-79-A	FRAMING BRACKETS	" " " "	37½	TO	62½
S11-79-B	SHELL FRAMING	" " " "	"	"	"
S11-80-A	FRAMING BRACKETS	" " " "	11½	TO	37½
S11-80-B	SHELL FRAMING	" " " "	"	"	"
S11-81-A	WEB FRAMES	I.B. TO W.T. FLAT	148, 154		
S11-81-B	" "	W.T. FLAT TO 3RD DK.	"		
S11-96	CHAIN LOCKER		11, 12, 13 & 14		
S11-243	MSCL. BHD.S BELOW 3RD DK.				
S11-247	WEB FRAMES	3RD DK. TO 2ND DK.	148, 154 & 160		

(31)

ORDER DEPARTMENT

YARD PRINTS & ORDERS ____ BILLS & ORDERS ____

PRINTS ____

REMARKS ____

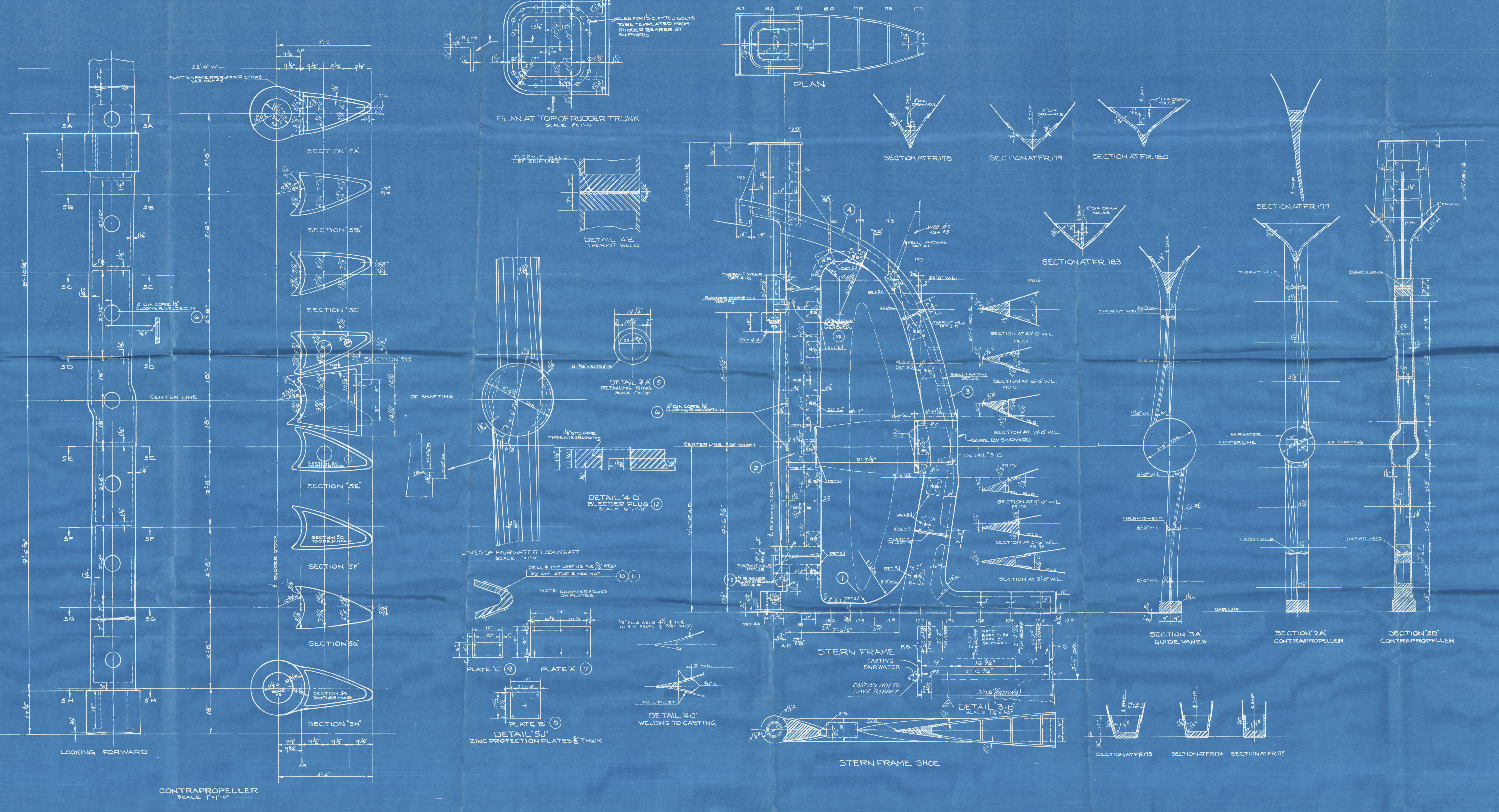
DATE ____ SIGNED ____

2-2-44 CB JCG 14 HE AHP TS ML 2/25/4 HE 2AH AHP 4ML 4FN TS WE 4FS PD	ABS 30S RH EN 35W 3/15/4 2EH 3/20/44 6 Martin 4ML 4FN 4FS TS WE	PD ABS 30S RH EH 4SW HE 3AH AHP 4/5/44 7 Martin 4/13/44 HE 3AH AHP	4ML 4FN 4FS TS WE PD ABS 30S RH EH 35W	4/27/4 4ML 4FN 4FS TS WE PD ABS 30S RH EH 4SW HE 2AH	6/29 HE 2AH AHP 4ML 4FN 4FS TS WE PD ABS 30S RH EH 4SW	7/6/4 HE 2AH AHP 4ML 4FN 4FS TS WE PD ABS 30S RH EH 45W MAIL NY	7/7 4FN 10/11 HE 2AH AHP 4ML 4FN 4FS TS WE PD ABS 30S RH EH 45W NN NY

GROUP:

© 2020 Lloyd's Register Foundation

002877-007990-010



MARK	PANEL NO.	ALTERATIONS	DATE	O.K.	AUTH.D	APPD.	DATE
A		NC. PLAN NO'S & MAT. GROUP NO'S. ADDED TO SUIT YARD PRACTICE	2/23/44 A.J.M.	2/25/44 RHM	3/1/44 ALG		
B	3'	ADDITIONAL MATERIAL ADDED TO PROPELLOR POST TO ALLOW TOLERANCE FOR MACHINING.	2/29/44 A.J.M.	2/29/44 RHM	3/1/44 ALG		
C		PLAN MADE MADE APPLICABLE FOR ADDITIONAL CONTRACT BY ALTERING AKA, M.C., & N.C. HULL NUMBERS.	R.C.P. 12/6/44				

NOTES:

A. THIS DRAWING REPLACES N. N. DRAWING 178018 M. C. NO 1346-S11-3-1 ER FOR HULLS LISTED BELOW. ALL MATERIAL ORDERED ON ORIGINAL PLAN PREVIOUSLY APPROVED BY M.C. (NO CHANGE).

1. STERN FRAME CASTINGS TO PASS INSPECTION AND BE APPROVED BY "AMERICAN BUREAU OF SHIPPING."
2. MOLD LOFT TO FURNISH ALL NECESSARY TEMPLATES TO PATTERN MAKER.
3. INSIDE OF RUDDER POST TO BE COATED INTERNALLY WITH OXIDIZED ASPHALT OR M.C. RUST PREVENTATIVE XXXIX.
4. ALL MACHINE WORK TO BE DONE BY SHIPYARD.

SEE ORDER SHEET #179113 FOR ITEMS MADE BY N.N. ON JOB ORDER #2218 V

BILL OF MATERIAL - ONE SHIP

Nº ITEMS REQD	ITEM Nº	NAME	MATERIAL	REMARKS	WT EACH	PURCHASED BY N.N.S.& D.D. CO.	PURCHASED BY N.C.S. CO.	SUPP. BY U.S.M.C.
1	1	SHOE	CAST STEEL		15500#			
1	2	RUDDER POST	CAST STEEL		8870#			
1	3	PROPELLER POST	CAST STEEL		8565#			
1	4	SHELL CASTING	CAST STEEL		8820#			
2	5	RETAINING RING PL	M. STEEL					
7	6	SEAL PLATE	M. STEEL					
1	7	PROTECTION PLATE "A"	ZINC (ROLLED)					
32	8	PROTECTION PLATE "B"	ZINC "					
2	9	PROTECTION PLATE "C"	ZINC "					
174	10	⅝" STUD 1 5/16" LONG	STEEL					
174	11	⅝" D. HEX NUT	STEEL					
3	12	BLEEDER PLUG	BRONZE	DET. 4-D				

M C HULL	N C HULL	A K A HULL	CONVERSION YARD	M C HULL	N C HULL	A K A HULL	CONVERSION YARD
1405	150			1404	149		
1403	148			1402	147		
1401	146			1400	145		
1399	144			1398	143		
1397	142			1396	141		
1395	140			1394	139		
1393	138			1392	137		
1391	136			1390	135		
1389	134			1388	133		
1387	132			1386	131		
1385	130			1384	129		
1383	128			1382	127		

Nº	REFERENCES	C2-S-AJ1 N.N. Nº	C2-S-AJ1 N.C. Nº	C2-S-AJ3 N.N. Nº	C2-S-AJ3 N.C. Nº
1.	SHELL PLTG.	178034	S11-1-1	179573	179573
2.	CENTER VERTICAL KEEL	178000	S11-4-1	179539	179539
3.	STERN FRAMING	178008	S11-3-6	179554	179554
4.	STEERING GEAR FLAT	178024	S11-6-5	179568	179568
5.	RUDDER	178051	S22-0-2	179595	179595
6.	RUDDER STOCK, BEARER ETC.	178052	S22-0-1	179596	179596
7.	GOLDSCHMIDT-CONTRAGUIDE RUDD. & GUIDE V.	178215			

DESIGN No. C2-S-AJ 3
CONVERSION OF C2-S-AJ 1

UNITED STATES MARITIME COMMISSION
M. C. HULL Nos. 1382 TO 1405 1696-1703 & M. C. DWG. No.

NAVY DEPARTMENT
A. K. A. HULL Nos. 64-87 & 101-108

DESIGNED BY
NEWPORT NEWS SHIPBUILDING & DRY DOCK COMPANY
NEWPORT NEWS, VIRGINIA
HULL DEPARTMENT

SCALE ½" & 1" = 1 FT. DATE SCHED. DATE COMP. 2-11-44
DRAWN W. S. H. EXAMINED
CHECKED APPROVED J. P. Comstock.
CHARGEMAN DATE Feb. 12. 1944

N. N. JOB ORDER 644-V
N. N. DRAWING No. 179563

NORTH CAROLINA SHIPBUILDING COMPANY
WILMINGTON, N. C.
BUILDERS
N. C. HULL Nos. 127 TO 150 187-194 & N. C. DWG. No. 179563
CONVERSION YARD

DWG. TITLE
STERN FRAME

③

S.S. "Beatrice"
Baltimore Rpt.
8451

APPROVED AS NOTED IN
M. C. LET.
M. C. FILE
BY
BY
U. S. COAST GUARD

LLOYD'S REGISTER OF SHIPPING
17 BATTERY PLACE
NEW YORK N. Y.
Noted

EXAMINED AND FOUND CORRECT
SUPERVISOR OF SHIPBUILDING
DATE

PLAN APPROVED
DATE 2-15-44
E L Gayhart
FOR SUPERVISOR OF SHIPBUILDING

BUREAU OF SHIPS PLAN NUMBER (BASIC)
A.K.A.-64-S1103-507033

Fr.	Machine finish	rough.
Fs.	Machine finish	smooth.
B.	Buff	
Fg.	Finish ground.	
Ff.	Finish file.	

ORDER DEPARTMENT
YARD PRINTS & ORDERS BILLS & ORDERS
PRINTS
REMARKS
DATE SIGNED

2/21/44	WE	8/10
HE	HE	SW
AHP	2AH	
MB	AHP	
TS	4/7/44	
3/1/44	PT	
4 ML	5/9	
TS		
RH	3/30	
4 FN	6/7/44	
4 FS		
MS	4 FN	
3 SW	7/22	
3 OS	4 FN	

GROUP:

S11-27F STERN FRAME CASTING

①

MARK	PANEL NO.	ALTERATIONS	DATE	O.K.	AUTH'D	APP'D	DATE
A		N.C. PLAN NO'S. & GROUP NO'S. ADDED TO SUIT YARD PRACTICE.	2/24/44 A.J.M.	2/25/44 RHM	2/25/4		
B		PLAN MADE APPLICABLE FOR ADDITIONAL CONTRACT BY ALTERING AKA, M.C. & N.C. HULL NOS.	R.U.B. 8-2-44				

NOTES:

A. THIS DRAWING REPLACES N. N. DRAWING 178051 M. C. No. 1346-S-22-0-2ER FOR HULLS LISTED BELOW. ALL MAT'L. ORDERED ON ORIGINAL PLAN PREVIOUSLY APPROVED BY M.C. (NO CHANGE).

1. STEEL CASTINGS TO MEET REQUIREMENTS OF AMER. BUREAU OF SHIPPING.
2. RUDDER & FIXED PORTION OF RUDDER FAIRWATER TO BE FILLED WITH ASPHALTUM VARNISH, NAVY FORMULA #47 & DRAINED AFTER 24 HOURS.
3. SPOT FACE CASTINGS IN WAY OF BOLT HEADS & NUTS.
4. RUDDER TO BE WATERTIGHT & TESTED.
5. FOR UNSHIPPING RUDDER, ONE OF THE FOLLOWING METHODS TO BE USED –
   1. BURN OFF FAIRING PLATE AS INDICATED AND REMOVE PINTLES AND LOOSEN COUPLING.
   2. BURN OFF FAIRING PLATE AS INDICATED, JACK UP RUDDER & STOCK IN ONE PIECE UNTIL PINTLES ARE CLEAR OF GUDGEONS THEN LOOSEN COUPLING.
6. PC. #4 COUPLING BOLT, TO BE ORDERED 3¼" DIA. FOR MACHINING BY YARD.

BILL OF MATERIAL - ONE SHIP

NO ITEMS REQ'D.	ITEM NO.	NAME	MATERIAL	REMARKS	WT.	PURCHASED BY N.N.S. & D.D. CO	PURCHASED BY N.C.S. CO	SUPP. BY U.S.M.C
1	1	UPPER RUDDER FRAME	CAST STEEL		5030#			
1	2	LOWER RUDDER FRAME	" "		3525#			
1	3	STEEL TUBE	STEEL	18" O.D. x 13/16" THK.				
6	4	COUPLING BOLT (FITTED)	F'G'D. STEEL	3 1/32" DIA. - 11 1/8" LG.				
6	5	COUPLING NUT	" "	3" DIA.				
6	6	COTTER PIN	BRONZE	5/16" DIA. - 3½" LG.				
2	7	PINTLE	F'G'D. STEEL	DET. "4C"				
2	8	PINTLE SLEEVE	COMP. "G"	DET. "4C"				
2	9	PINTLE NUT	F'G'D. STEEL	DET. "4-B"				
2	10	COTTER PIN	BRONZE	7/16" DIA. - 8" LG.				
2	11	GUDGEON BUSHING	LAMINATED PHENOLITIC RESIN	DET. "4A"				
1	12	RUDDER LIFTING STOP	STEEL	DET. "5A"	121#			
5	13	TAP BOLT (FITTED)	BRONZE	1¼" DIA. - 3½" LG.				
1	14	RUDDER COUPLING (KEY)	STEEL					
2	15	F.H. CAP SCREW	BRONZE	¾" DIA. - 2" LG.				
4	16	PIPE PLUG	BRASS	1½" DIA. - CSK. HD.				
1	17	STEEL BAR (UPPER RUDDER)	M. STEEL					
1	18	STEEL BAR (LOWER RUDDER)	" "					
~~16~~	~~19~~	~~STUDS~~	~~STEEL~~	~~1" DIA. - 3½" LG.~~				
AS REQ'D.	20	RUDDER FILLING	ASPHALTUM VARNISH NAVY FORMULA #47	SEE NOTE #2				
4	21	F.H. MACH SCREW	BRONZE	½" DIA. - 1" LG.				
1	22	STEEL BAR (UPPER RUDDER)	M. STEEL					
1	23	3" STD. PIPE	STEEL GALV.					

SEE NOTE #6 → (ITEM 4)

NOTE - ITEMS 30 THRU 62 USED BY BILLERS

HULL	N C HULL	A K A HULL	CONVERSION YARD	M C HULL	N C HULL	A K A HULL	CONVERSION YARD
1405	150			1404	149		
1403	148			1402	147		
1401	146			1400	145		
1399	144			1398	143		
1397	142			1396	141		
1395	140			1394	139		
1393	138			1392	137		
1391	136			1390	135		
1389	134			1388	133		
1387	132			1386	131		
1385	130			1384	129		
1383	128			1382	127		

Nº	REFERENCES	C2-S-AJ1 N.N.Nº	C2-S-AJ1 N.C.Nº	C2-S-AJ3 N.N.Nº	C2-S-AJ3 N.C.Nº
1.	STERN FRAME	178018	S11-3-1	179563	179563
2.	RUDDER STOCK, BEARER & STUFFING BOX	178052	S22-0-1	179596	179596

Fr. ___ Machine finish ___ rough.
Fs. ___ Machine finish ___ smooth
B. ___ Buff.
Fg. ___ Finish ground.
Pf. ___ Finish file.

S.S. "Beatrice"
Baltimore Rpt. 8451

④

DESIGN No. C2-S-AJ 3
CONVERSION OF C2-S-AJ 1
UNITED STATES MARITIME COMMISSION
C. HULL Nos. ~~1382~~ 1696 TO ~~1405~~ 1703 M. C. DWG. No. ______

NAVY DEPARTMENT
A. K. A. HULL Nos. 64-87 & 101-108 INCL

DESIGNED BY
NEWPORT NEWS SHIPBUILDING & DRY DOCK COMPANY
NEWPORT NEWS, VIRGINIA
HULL DEPARTMENT

SCALE ¾, 1½ & 3" = 1 FT. DATE SCHED. ______ DATE COMP. 2-14-44
DRAWN W.S.H. EXAMINED RWDavis F.N. Bondy
CHECKED [illegible] APPROVED J.P. Comstock
CHARGEMAN [illegible] DATE Feb 14 1944
JOB ORDER 644-V
N. N. DRAWING No. 179595

NORTH CAROLINA SHIPBUILDING COMPANY
WILMINGTON, N. C.
BUILDERS
C. HULL Nos. ~~127~~ 187 TO ~~150~~ 194 N. C. DWG No. 179595
CONVERSION YARD

DWG. TITLE
RUDDER

Noted

BUREAU OF SHIPS
17 BATTERY PLACE
NEW YORK N.Y.

APPROVED AS NOTED IN
M. C. LET. ______ A. B. S. LET ______
M. C. FILE ______
BY ______
BY ______
U. S. COAST GUARD ______
EXAMINED AND FOUND CORRECT ______ PLAN
SUPERVISOR OF SHIPBUILDING
DATE ______
APPROVED
DATE ______
E. L. Gayhart [illegible]
FOR SUPERVISOR OF SHIPBUILDING

BUREAU OF SHIPS PLAN NUMBER (BASIC)
A.K.A.-64-S2200-507070

ORDER DEPARTMENT
YARD PRINTS & ORDERS ______ BILLS & ORDERS ______
PRINTS ______
REMARKS ______
DATE ______ SIGNED ______

2/22/44 HE 4-FN ABS
2/26/4 HE 4/7/44 PT
2AH
AHP
3OS
CPB 4SW
WE 9/13
4FS 4SW
PD
MS
EN
4ML
TS
RH

GROUP:
2216-101 RUDDER
④